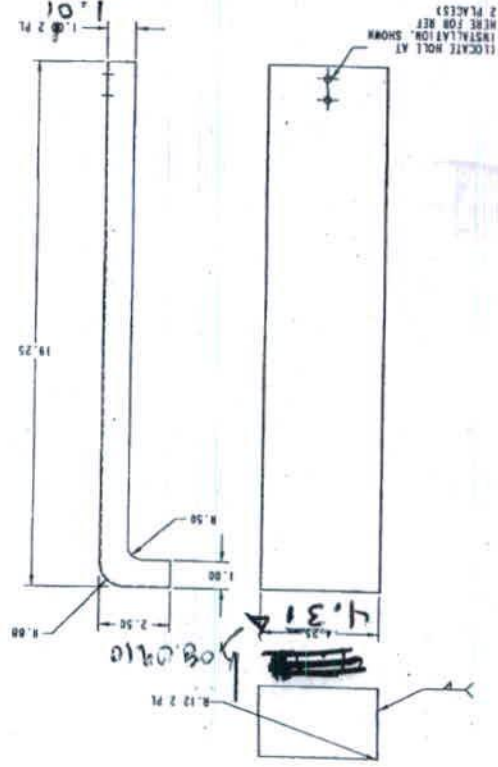
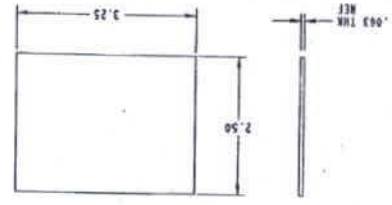


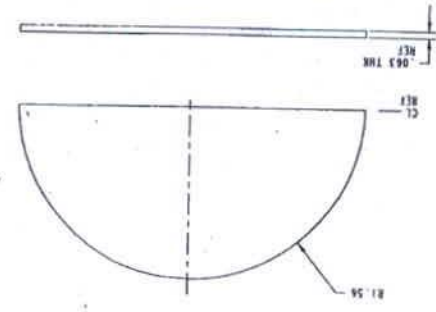
② - 69 90 DEGREE COVER PLATE
MATERIAL: .032 THK, 6061-T6, 00-A-250/11
SCALE: 8.500



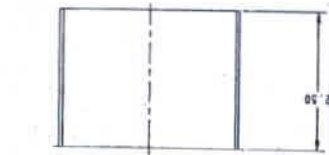
⑥ - 185 D-PAD BACK PLATE
MATERIAL: .063 THK, 6061-T6, 00-A-250/11
SCALE: 1.000



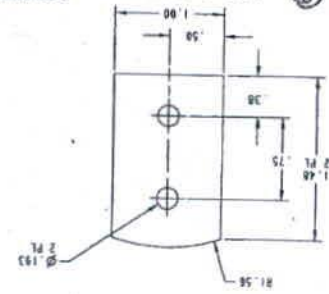
⑧ - 339 D-PAD TOP
MATERIAL: .063 THK, 6061-T6, 00-A-250/11
SCALE: 2.000



③ - 189 D-PAD FACE
MATERIAL: .063 THK, 6061-T6, 00-A-250/11
SCALE: 1.000



④ - 193 D-PAD BASE
MATERIAL: .125 THK, 6061-T6, 00-A-250/11
SCALE: 2.000



ORIGINAL

PREMIER AVIATION, INC.
1111 10th Street, Suite 100
B67-43001
D05UV8

RELEASED
COPY 17, 10

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 90 DEGREE COVER PLATE

Job Number: 41511

Part Number: PB674300169

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PG

PURCHASING



Comment: PURCHASING

SEND TO TALMAR FOR FOAM AND FABRIC

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

16.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-18

July

you will best

Q

Polish

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-69 PAR #: N/A Fault Category: Prod/Ins. Mfg NCR: Yes No DQA: A Date: 08/10/09
 Resolution: _____ Disposition: _____ QA: N/C Closed: D Date: 08/10/09

NCR: <u>41511-1</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/15	# 80	All 10 parts scrap due to welder trying to weld parts together without proper tooling.	<u>[Signature]</u> 08/09/15	parts are too badly bent into shape → make tool to form part correctly	<u>[Signature]</u> 08/09/15 <u>[Signature]</u> 08/09/15	<u>[Signature]</u> 08/09/15 <u>[Signature]</u> 08/09/15 <u>[Signature]</u> 08/09/15	<u>[Signature]</u> 08/09/15	<u>[Signature]</u> 08/09/15

NOTE: Date & initial all entries

Tuesday, 19/08/2008 4:07:23 PM
Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 90 DEGREE COVER PLATE

Job Number: 41511

Part Number: PB674300169

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/10 xlv

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg B67-43001

Pn

08-09-15 10

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Scanned

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Date
USTuesday, 19/08/2008 4:07:23 PM
Julie Lecocq

Process Sheet

TALMAR

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : 90 DEGREE COVER PLATE

Job Number : 41511-1

Estimate Number : 13405

P.O. Number :

This Issue : 19/08/2008 S.O. No. :

Prsht Rev. : NC

First Issue : // Type : SMALL /MED FAB

Previous Run : 40069

Part Number : PB674300169

Drawing Number : B6743001 PAGE25

Project Number : N/A

Drawing Revision : B1

Material :

Due Date : 18/09/2008

Qty: 30 Um: Eac

Written By :

Checked & Approved By : JUL 08.8.20

Comment : Est Rev:A 08-06-20 new issue DD verified by:ec

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6S032

6061-T6 Sheet 0.032"

Comment: Qty.: 1.4234 sf(s)/Unit Total : 42.7014 sf(s) 18147
6061-T6 Sheet 0.032" IB 8-9-8

2.0

WATER JET

FLOW WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg B67-43001

Dwg Rev: B1

Prog Rev: B1

****grain direction along 9.144" ****

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE

Comment: NC BRAKE

Bend as per Dwg B67-43001